

Work Order ID 65490

January 18, 2011 3:13:04 PM



Page 1

Item ID: D3480-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyeball Adapter Flange

Start Date: 1/18/11 Start Qty: 4.00



Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 1/10/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3480

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3480**USE D3480-1 CUTTING FILE**** ☐ Dwg

304.018

Rev: C ☐ Prog Rev: CB11-1-265

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-1-26

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8.1.10.12645

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3480-5

Accept



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Item Name: Eyeball Adapter Flange

Start Date: 1/18/11 Start Qty: 4.00



Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

0.00

Small Fab

Memo

1-Form as per dwg D3467 using DT8856□2-Deburr

Small Fab

SP 11/01/22

4

(X0)

PS

140

QC5- Inspect part completeness to step on W/O-

0.00



0.00

Memo

QC

Quality Control

Sulu 126

(74)

150

Identify as per dwg & Stock Location: Cd

0.00



0.00

Memo

Packaging

Packaging

11/1/26sf

(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3460-5 PAR #: _____ Fault Category: Small Prob NCR: Yes No DQA: [Signature] Date: 11/01/26
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 11/01/27

NCR: <u>65490</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/01/26</u>	<u>130</u>	<u>1 piece was scrap moved when formed R.C process</u>	<u>[Signature]</u> <u>11/01/26</u>	<u>Scrap & destroy</u>	<u>11/01/26</u>	<u>S</u> <u>11/01/26</u>	<u>[Signature]</u> <u>11/01/26</u>	<u>[Signature]</u> <u>11/01/26</u>

NOTE: Date & initial all entries

Work Order ID 65490

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Page 3

Item ID: D3480-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyeball Adapter Flange

Start Date: 1/18/11 Start Qty: 4.00



Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/27 JJ

CL 11/01/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 18, 2011 3:13:04 PM

Page 1

Work Order ID: 65490

Parent Item: D3480-5

Parent Item Name: Eyeball Adapter Flange



Start Date: 1/18/11

Required Date: 1/31/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev. A 06.02.07 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S26GA

Purchased

No

sf

109.6600

0.320160



BIL-26

304/316 0.018 SHEET

Location

Loc Qty

Loc Code

MAT20

109.66

109398

20.06

112885

89.6

112885

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

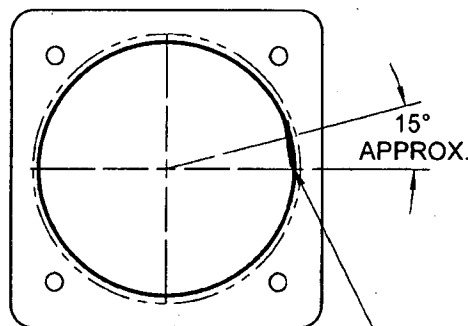
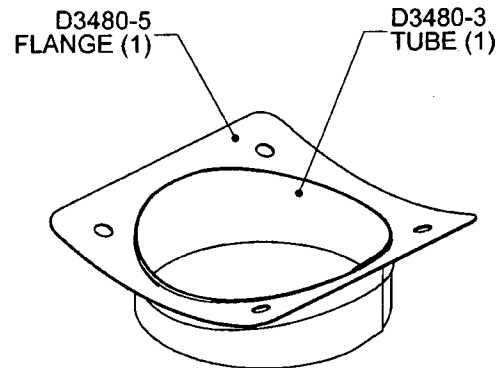
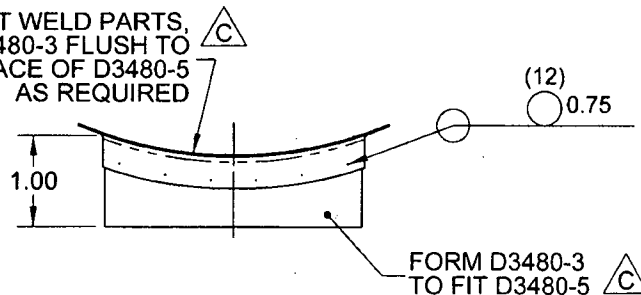
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. C SHEET 1 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2
A	06.02.06	NEW ISSUE	
B	06.08.29	D3480-3 0.50 was 0.40/D3480-3F 8.930 was 9.330	
C	08.12.19	D3480-3 PICTORIAL CHG PER D3480-3F (SHT 1 & 4); ADD/REV TOL (SHT 3-5); ADD MFG NOTE (SHT 4); MATL SPEC WAS MIL-S-5019	

RELEASE
09/01/2019ALIGN WELD
SEAM OF D3480-3
AS SHOWNSPOT WELD PARTS.
TRIM D3480-3 FLUSH TO
SURFACE OF D3480-5
AS REQUIREDSHOP COPY
RETURN TO
ENGINEERING
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WITHOUT NOTICE
WORK ORDER
NO. 65490
*C/L 11/01/19***D3480-041 EYEBALL INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

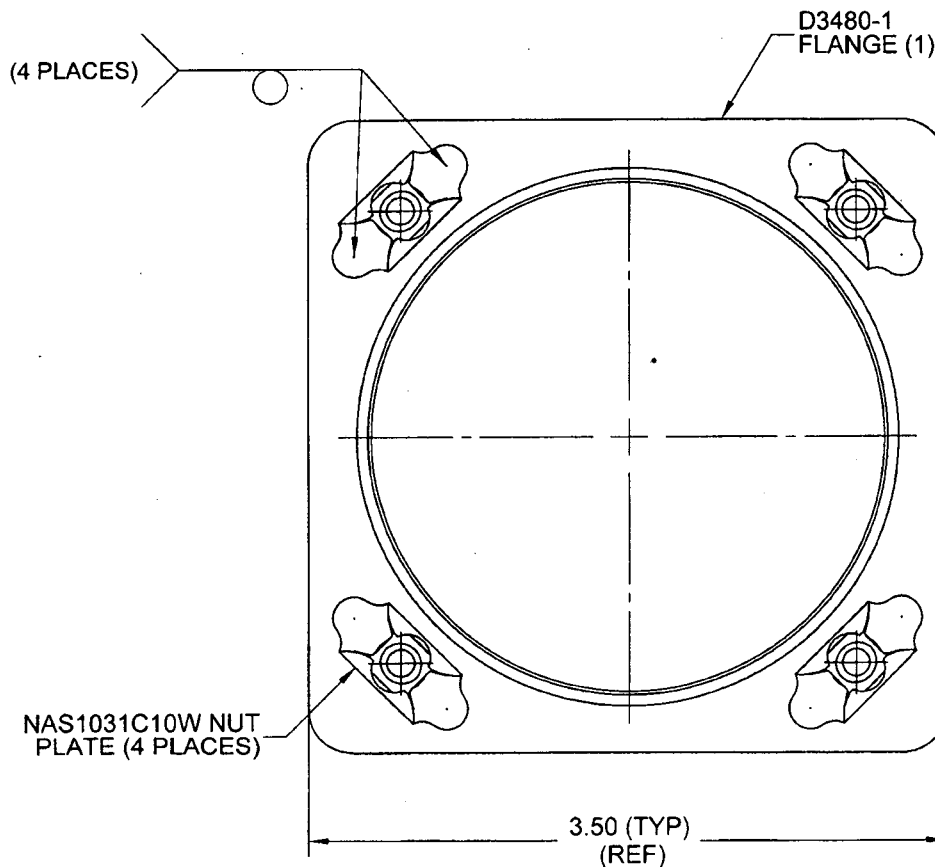
QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3480	REV. C SHEET 2 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:1

RELEASE
8/01/30 M.B.W.

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NO. 65490

D3480-043 EYEBALL ADAPTER**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

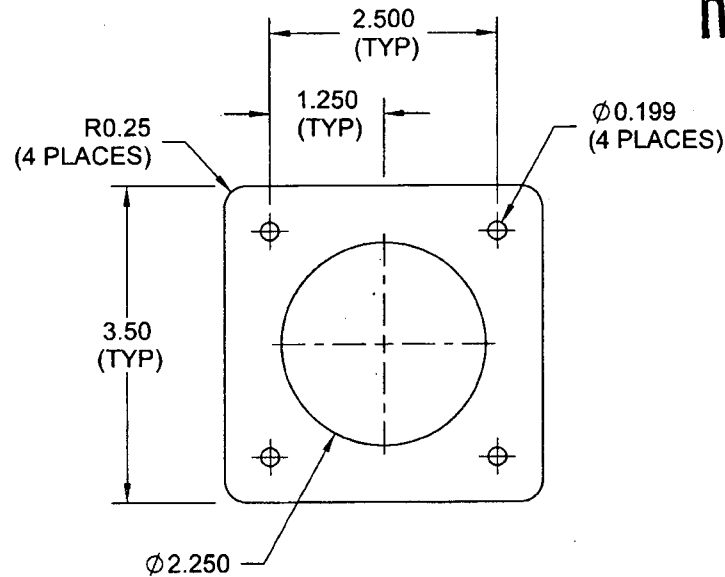
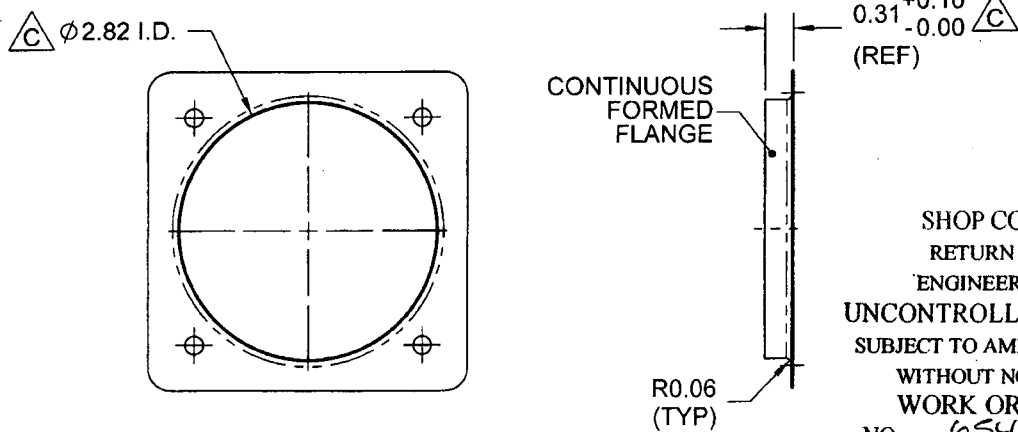
QTY -043	P/N	DESCRIPTION
X	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

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DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2

RELEASED
[Stamp]**D3480-1F FLAT PATTERN****D3480-1 FLANGE**
(MAKE FROM D3480-1F)**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle C$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

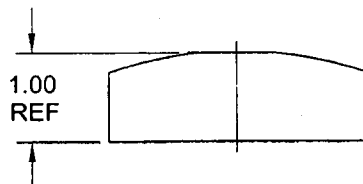
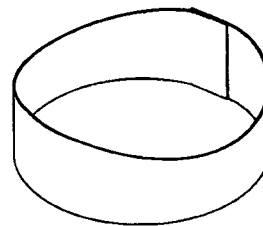
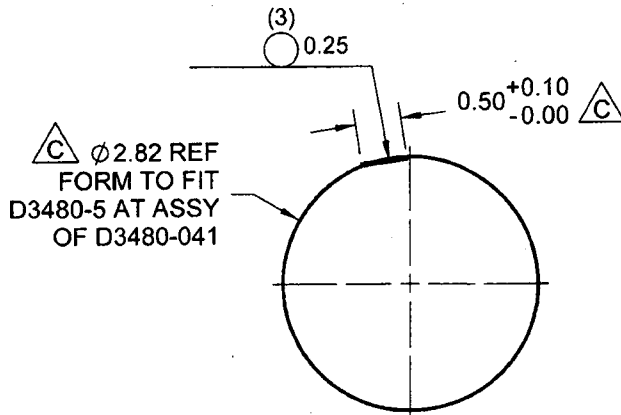
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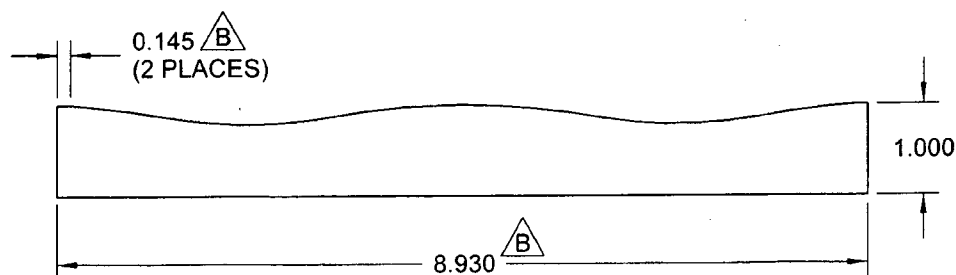
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. C SHEET 4 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2

RELEASE
9/6/30 M.D.**D3480-3 TUBE**

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WORK ORDER
NO. 65490

**D3480-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle C$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

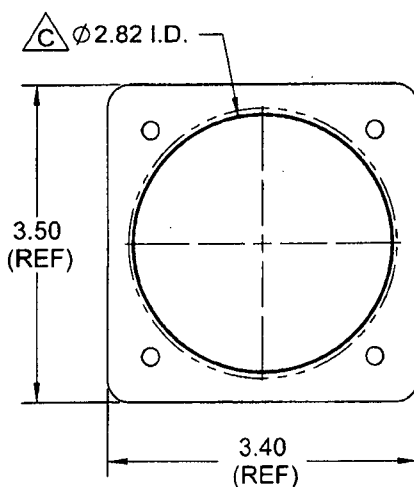
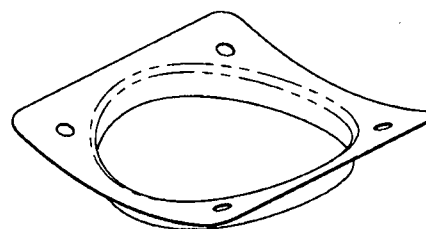
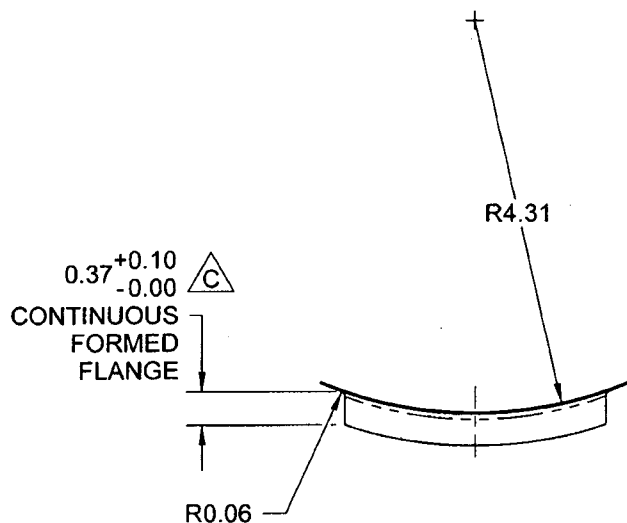
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. C SHEET 5 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2

RELEASED
9/6/30 MP



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WITHOUT NOTICE
WORK ORDER
NO. 65490

D3480-5 EYEBALL ADAPTER FLANGE

NOTES:

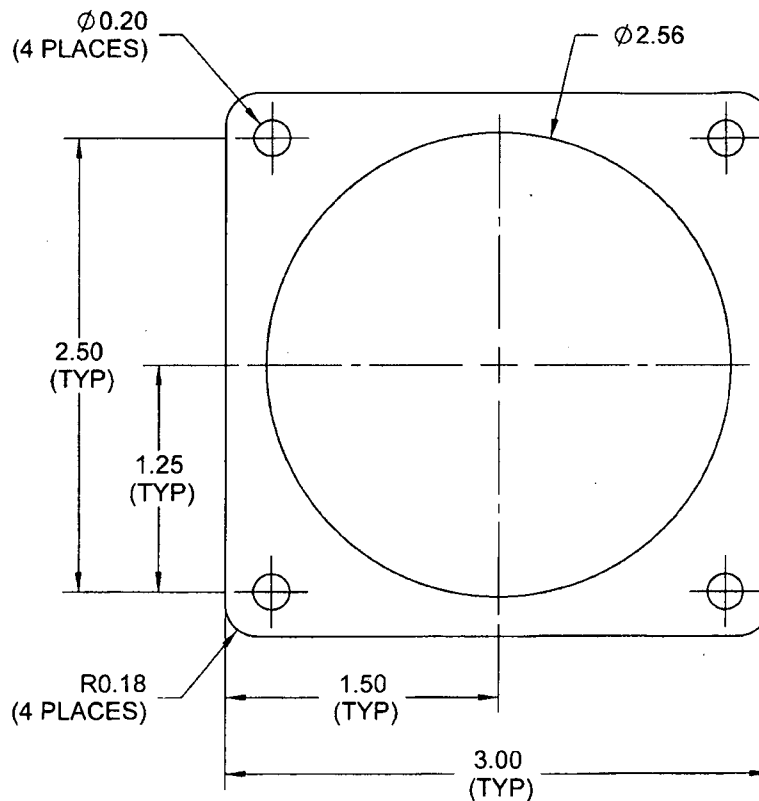
- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>PA</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. C SHEET 6 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:1

RELEASED
9/6/30 MP

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NO. 65490

D3480-7 GASKET**NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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